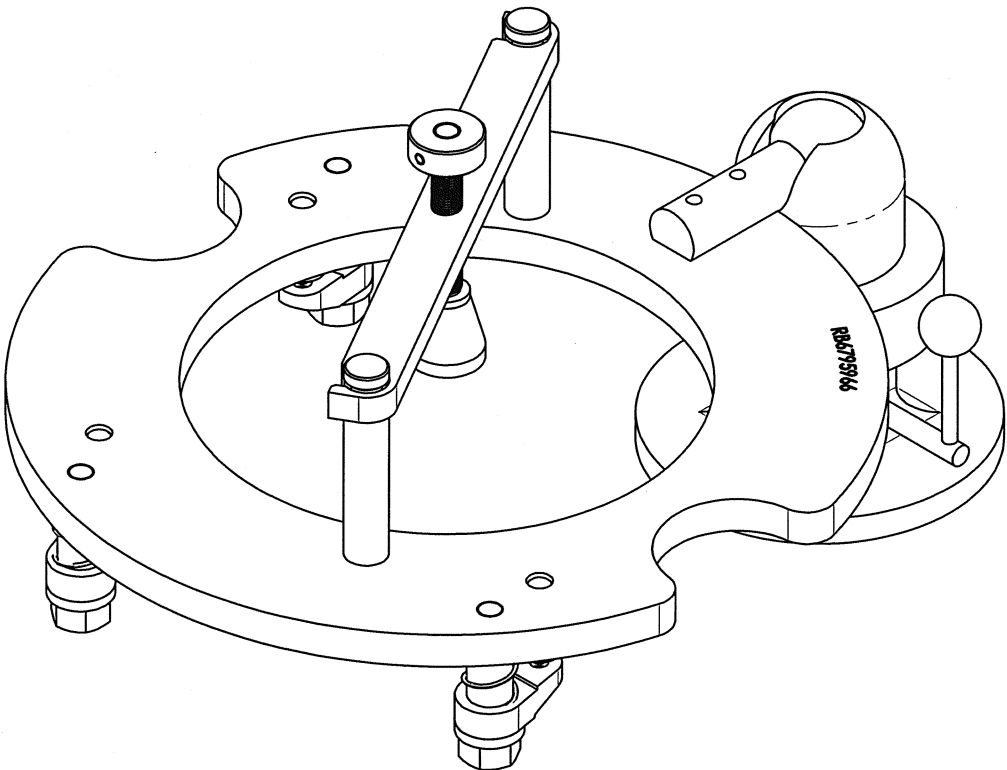


ITEM #	QTY	PART #	PART TITLE
-1	1	RB6795966-1	PLATE ASSY
-4	2	RB6795966-4	POST
-5	1	RB6795966-5	BAR
-6	1	RB6795966-6	KNOB
-7	1	RB6795966-7	JACK SCREW
-8	1	RB6795966-8	SHOE
-9	1	RB6795966-9	TOE CLAMP #1
-10	1	RB6795966-10	TOE CLAMP #2
-11	1	RB6795966-11	TOE CLAMP #3
12	3	McMaster#91030A033 OR EQUIV	BLACK OXIDE STEEL FLANGE NUT 1/2"-13 X 11/16" HEIGHT
13	1	MS16555-344	PHOSPHATE COATED STEEL DOWEL PIN 3/16" X 1-1/4" LG.
14	1	MS51975-1	CAD PLATED STEEL HEX SOCKET SHOULDER SCREW 1/4" DIA. X 3/8" LG. X #10-24 X 3/8" LG.
15	2	MS24667-42	CAD PLATED STEEL HEX SOCKET FLAT HEAD CAP SCREW 5/16"-18 X 1-1/4" LG.
16	3	NAS1454-8A-0300	CAD PLATED STEEL THREADED ROD 1/2"-13 X 3" LG.
17	3	CENTURY SPRING #2881	ZINC PLATED STEEL COMPRESSION SPRING CLOSED AND GROUND ENDS 0.906 OD X 0.062 WIRE DIA. 9.6 LBS MAX LOAD
18	1	WILTON #301 OR EQUIV	STEEL POWER ARM TWO MOUNTING HOLES 5/16"-18 X 1" APART



RB6795966 COMPRESSOR FIXTURE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 13 WITH ITEM -7, AND REMOVE EXCESS
 - 9) INSTALL ITEM 15, ITEM 14, ITEM 12 AND ITEM -4 HAND TIGHT
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

FOR OLD REV'S SEE PREVIOUS PDFs TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -1 CHANGED FOR ITEM -2 ITEM -2 CHANGED FOR ITEM 17 ITEM -3 ESSENTRA #FNC-5 CHANGED FOR ITEM 12 McMaster#91030A033 ITEM -4 ESSENTRA #AMS-242 CHANGED FOR ITEM 16 NAS1454-8A-0300 ITEM -5 WELDMENT CHANGED FOR SINGLE PART ITEM -9 ITEM -5A & -5B DELETED ITEM -6 CHANGED FOR ITEM -3 ITEM -7 McMaster#98381A512 CHANGED FOR ITEM 13 MS16555-344 ITEM -8 CHANGED FOR ITEM -6 ITEM -9 CHANGED FOR ITEM -8 ITEM -10 ESSENTRA #MMS-2 CHANGED FOR ITEM 14 MS51975-1 ITEM -11 CHANGED FOR ITEM -7 ITEM -12 WELDMENT CHANGED FOR SINGLE PART ITEM -10 ITEM -12A DELETED ITEM -15 CHANGED FOR ITEM -5 ITEM -16 McMaster#91253A585 CHANGED FOR ITEM 15 MS24667-42 ITEM -17 CHANGED FOR ITEM -4 ITEM -19 WELDMENT CHANGED FOR SINGLE PART ITEM -11 ITEM -19A DELETED ITEM -1 ASSY ADDED ORIENTATION OF ITEMS -6 CORRECTED ITEM -2 MATERIAL 6061 FINISH CLEAR ANODIZE CHANGED FOR 6061-T6/7075-T6 FINISH RED ANODIZE ITEM -3 DIMENSION Ø.4391/.4387 CHANGED FOR Ø.4383/0.4375, DIMENSION R0.008 MAX 2 PL ADDED, DIMENSION 0.03 X 45.0° CMF 2PL ADDED ITEM -4 DIMENSION .56 CHANGED FOR 0.560, DIMENSION R0.008 MAX 2PL ADDED, DIMENSION 0.03 X 45.0° CMF 3 PL ADDED, CENTER DRILL ADDED, MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 RC) ITEM -5 DIMENSION 10.00 CHANGED FOR 10.000, DIMENSION 2X .53 CHANGED FOR 0.532 2PL, DIMENSION Ø.75 CHANGED FOR Ø.750, MATERIAL A36/1018/1020 HR CHANGED FOR A36/1018/1020/1025 HR ITEM -6 Ø.1883/.1880 CHANGED FOR Ø.194, DIMENSION Ø.4382/.4375 CHANGED FOR Ø.438, DIMENSION .5 CHANGED FOR 0.50, MATERIAL A36/1018/1020 HR FINISH BLACK OXIDE CHANGED FOR A36/1018/1020/1025 HR FINISH ZINC PLATE YELLOW ITEM -7 DIMENSION R0.008 MAX ADDED, THREAD RELIEF ADDED, DIMENSION .250 CHANGED FOR 0.25, DIMENSION Ø.4359/.4349 CHANGED FOR Ø.425, CENTER DRILL ADDED, DIMENSION Ø.1874/.1869 CHANGED FOR Ø.1875/0.1867 ITEM -8 MATERIAL BRASS CHANGED FOR BRASS 360, DIMENSION R0.03 2 PL ADDED, DIMENSION R0.008 MAX ADDED, DIMENSION Ø.875 CHANGED FOR Ø.875 +0/-0.005, DIMENSION Ø.281 CHANGED FOR Ø.257, DIMENSION .13 CHANGED FOR 0.130, DIMENSION .03 X 45° CHANGED FOR 0.03 X 45.0° CMF 2 PL		19-750	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM	TOOL PART # RB6795966	
CHECKED	KPT	REV. F	
MFG. APPR.	JFC	SHEET 1 OF 13	
APPROVED	VP	TITLE COMPRESSOR FIXTURE ASSY	
DATE 2019-08-20		SCALE NTS	
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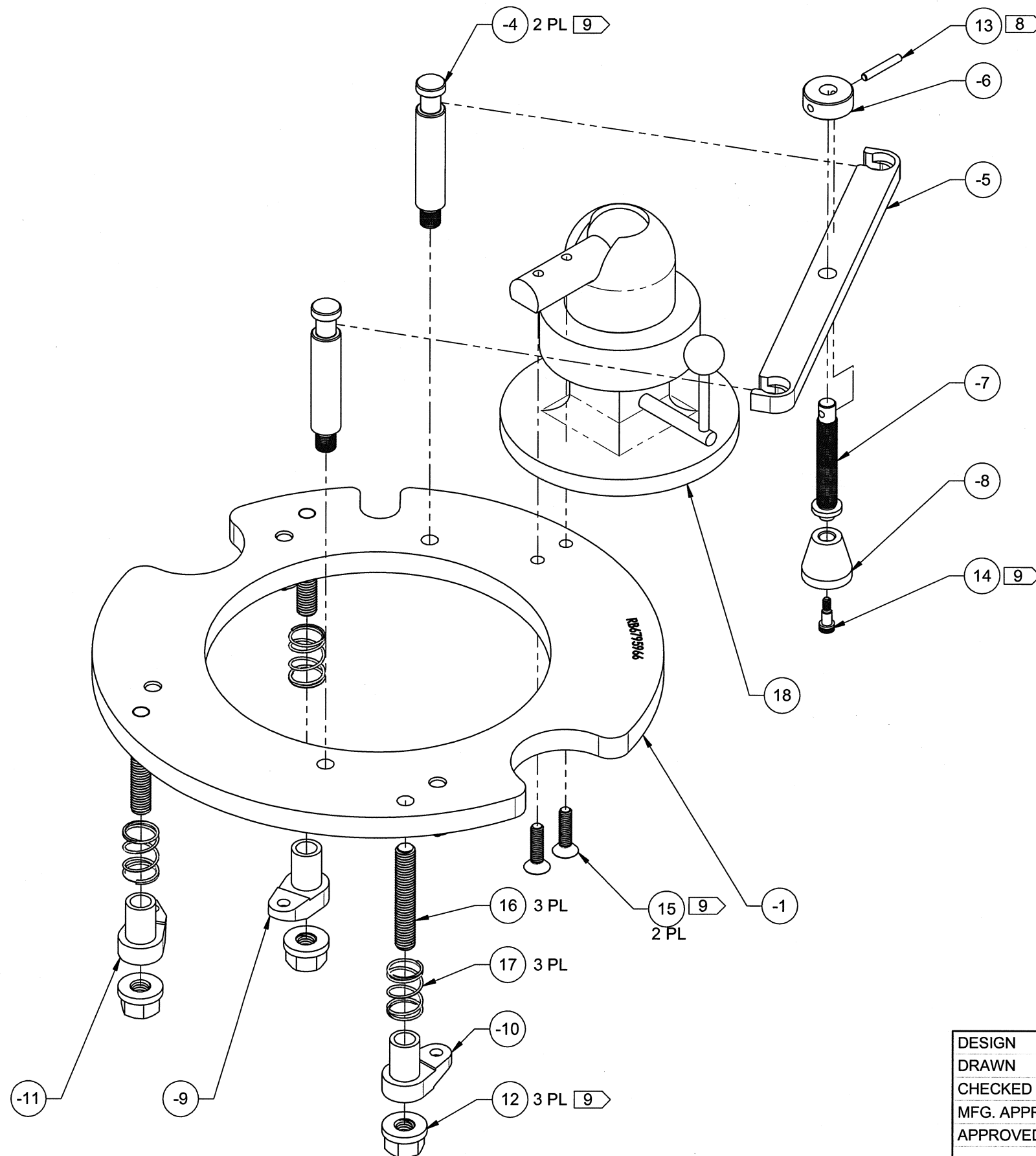
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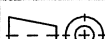
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DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 2 OF 13
APPROVED		TITLE	SCALE
		COMPRESSOR FIXTURE ASSY	NTS 
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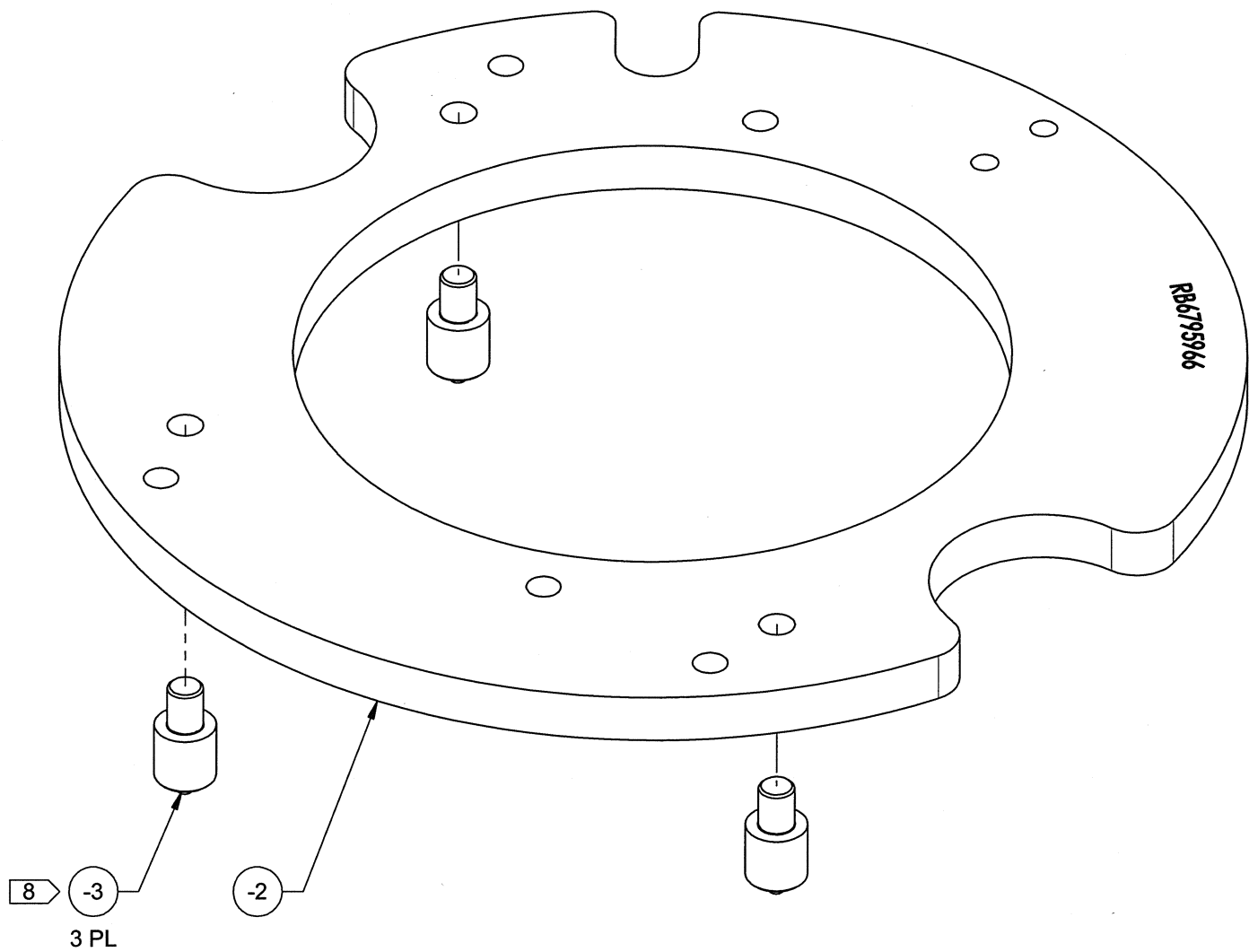
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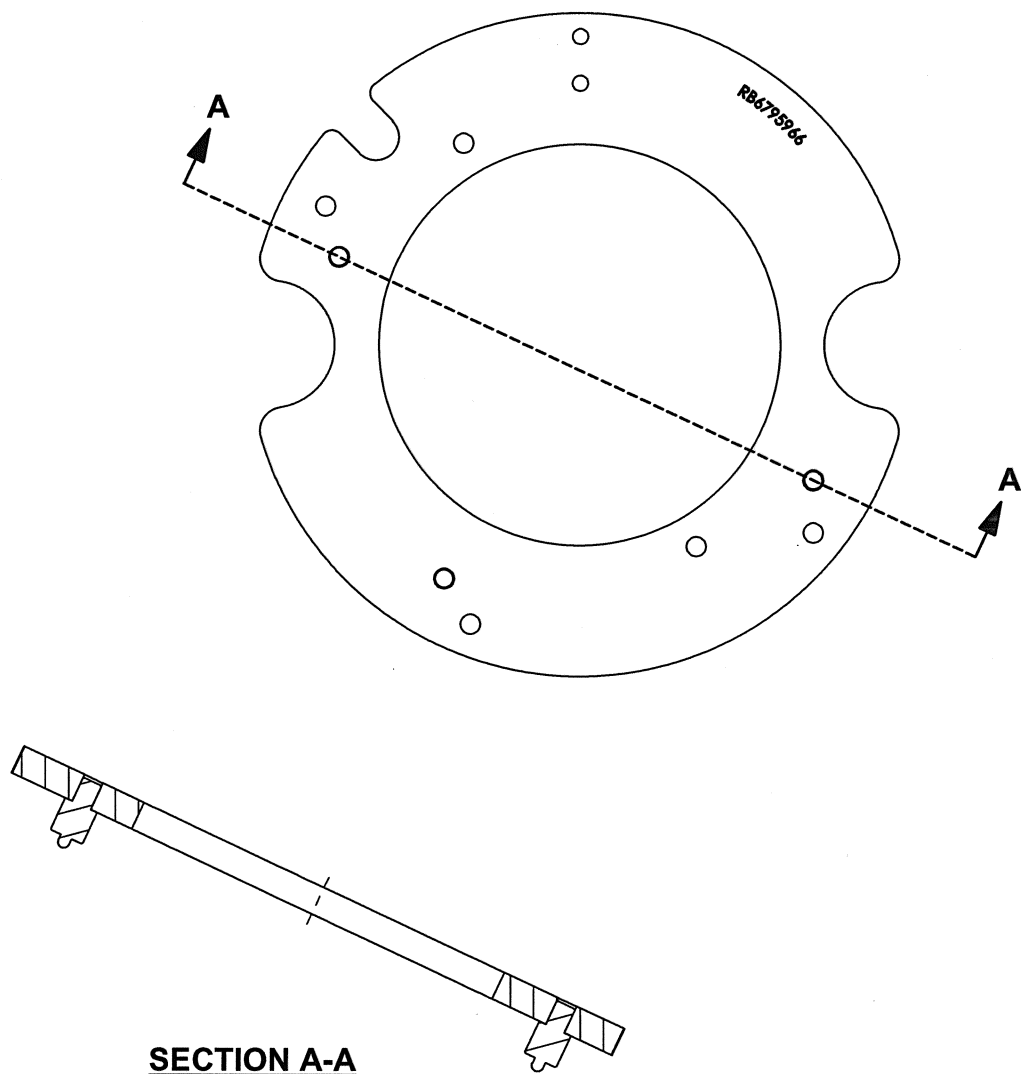
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB6795966-2	PLATE
-3	3	RB6795966-3	LOCATING BUTTON



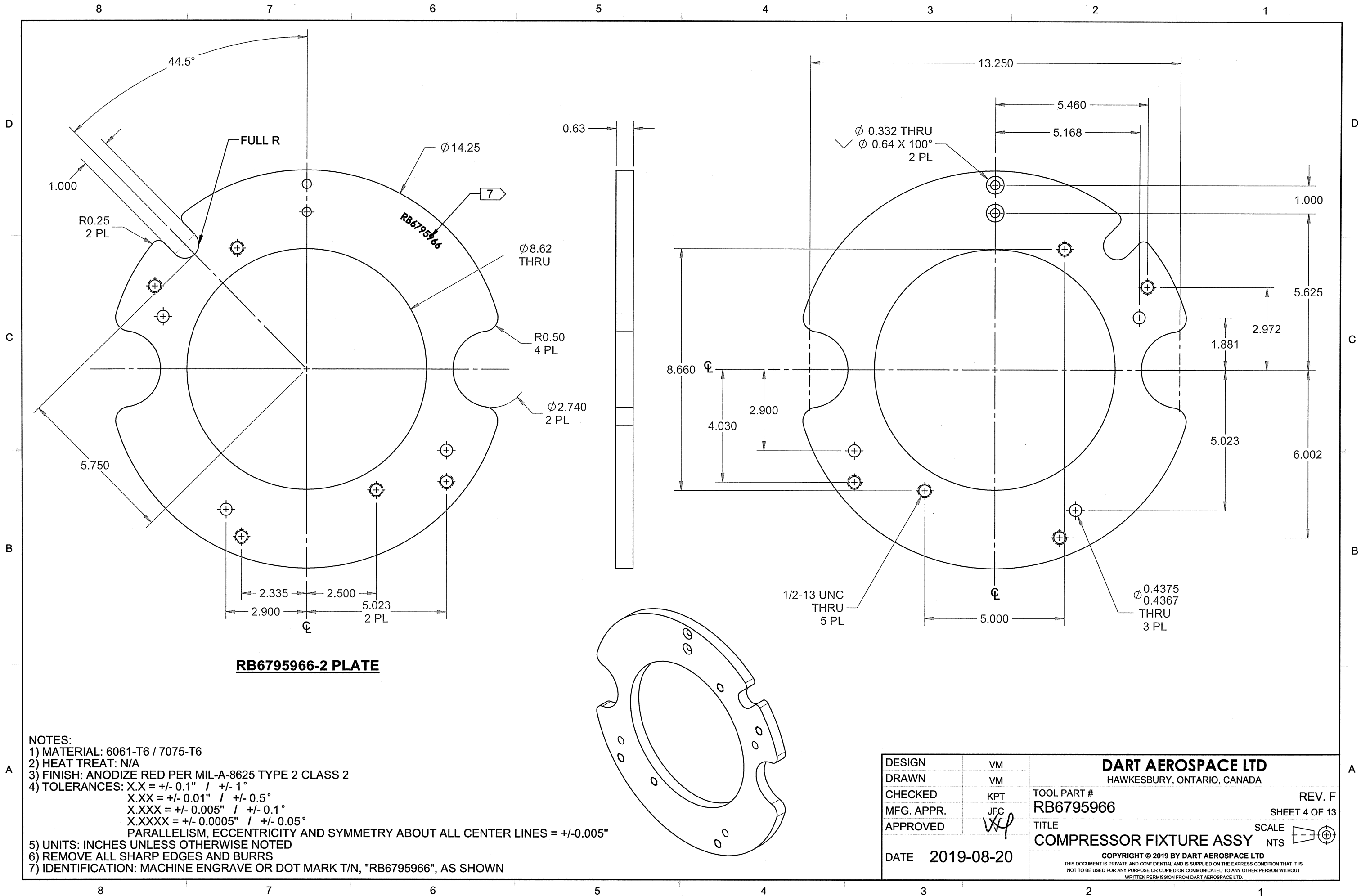
RB6795966-1 PLATE ASSY

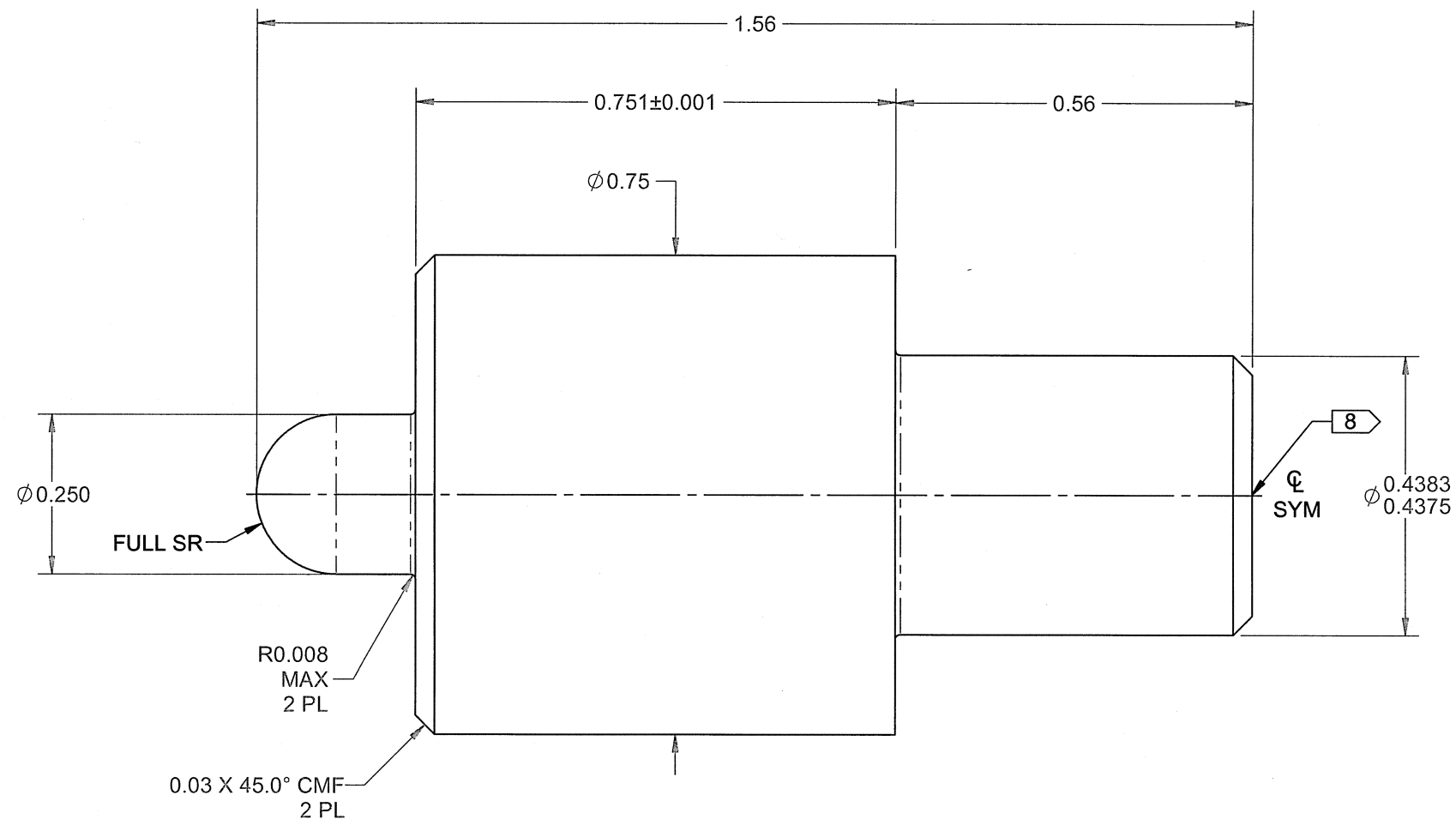


SECTION A-A

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -3 WITH ITEM -2, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 3 OF 13
APPROVED	WJ	TITLE	SCALE
DATE	2019-08-20	COMPRESSOR FIXTURE ASSY	NTS
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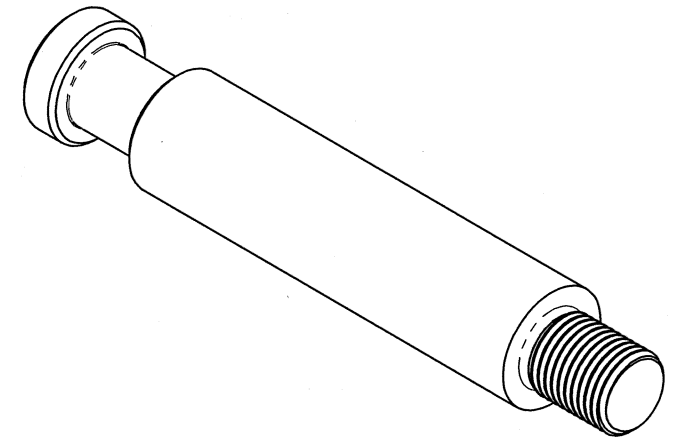
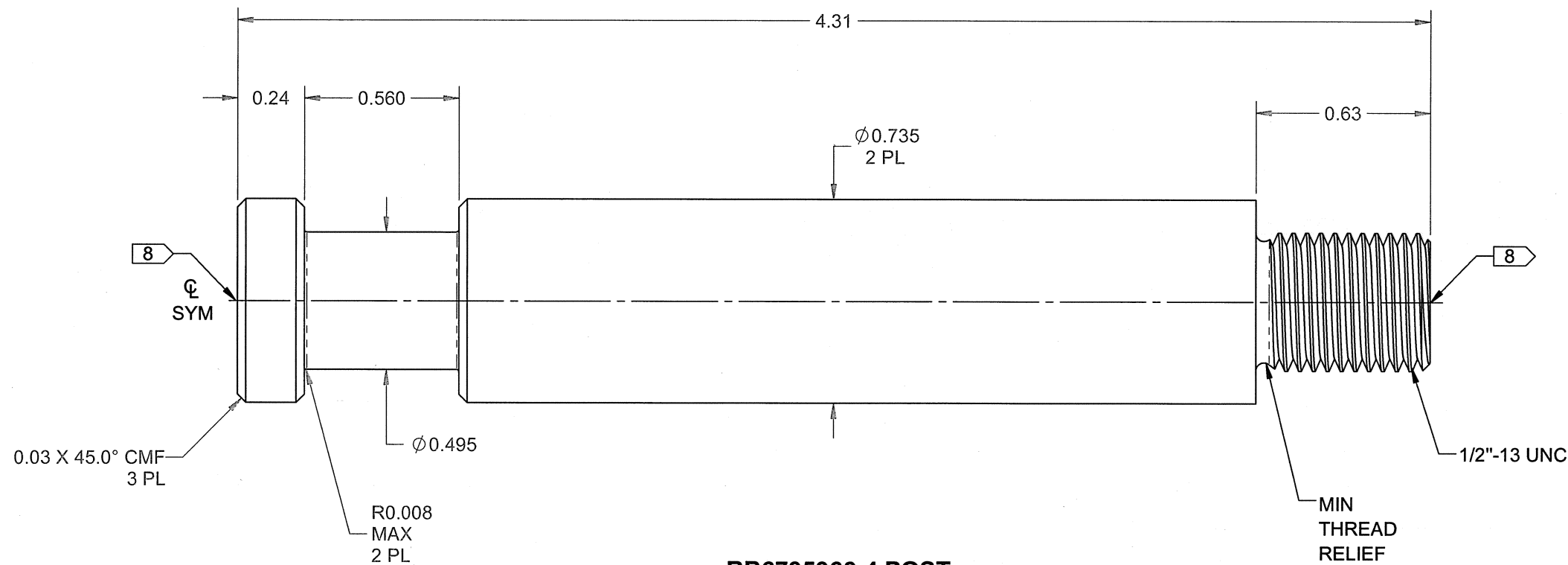




RB6795966-3 LOCATING BUTTON

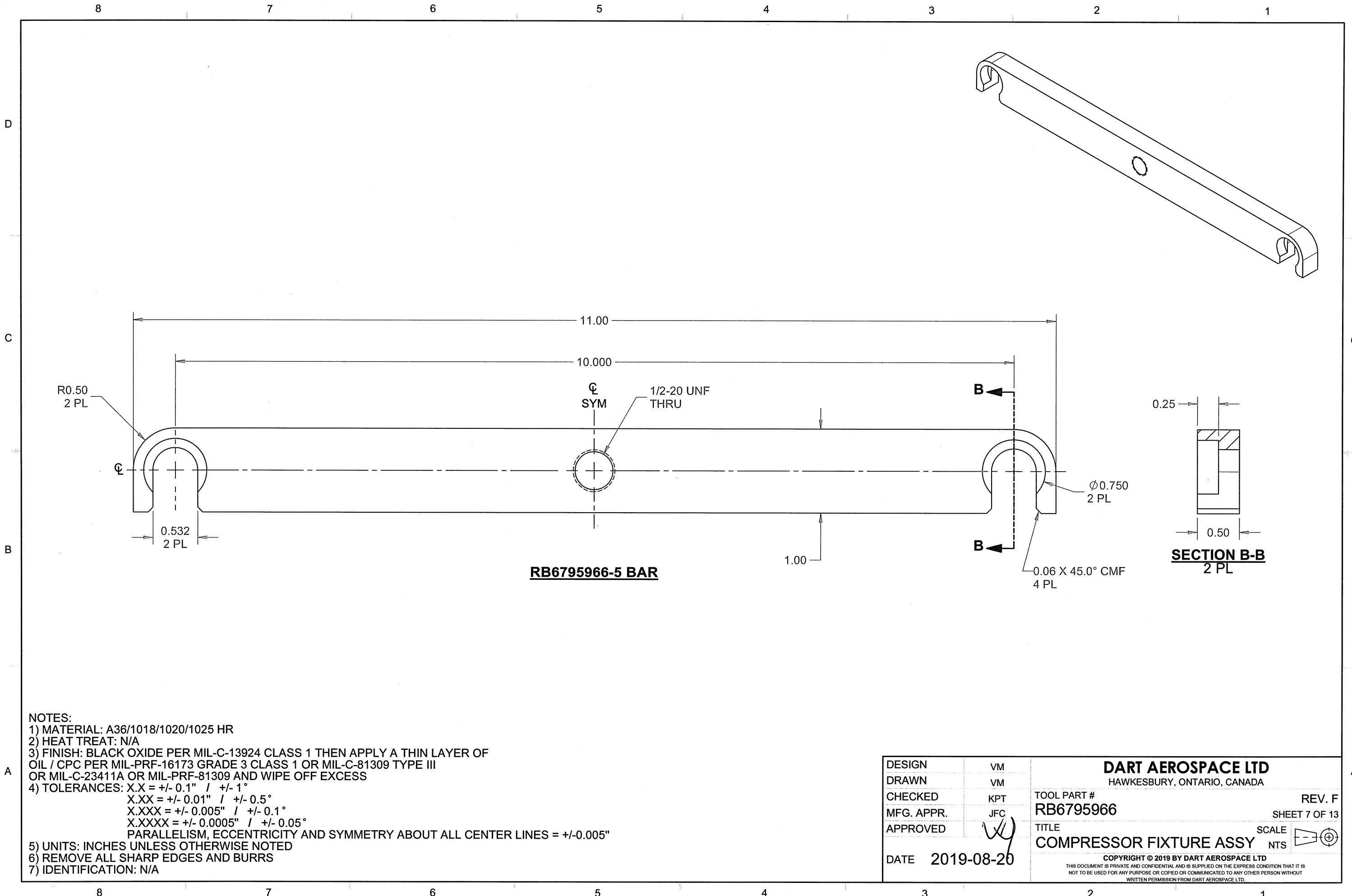
- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: 50-60 Rc
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD		REV. F
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KPT	TOOL PART #	RB6795966	
MFG. APPR.	JFC	TITLE		
APPROVED		COMPRESSOR FIXTURE ASSY	SCALE NTS	
DATE	2019-08-20	COPYRIGHT © 2019 BY DART AEROSPACE LTD		
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- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 6 OF 13
APPROVED	WJ	TITLE	SCALE
		COMPRESSOR FIXTURE ASSY	NTS
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NOTES:
1) MATERIAL: A36/1018/1020/1025 HR
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 7 OF 13
APPROVED		TITLE	SCALE
		COMPRESSOR FIXTURE ASSY	NTS
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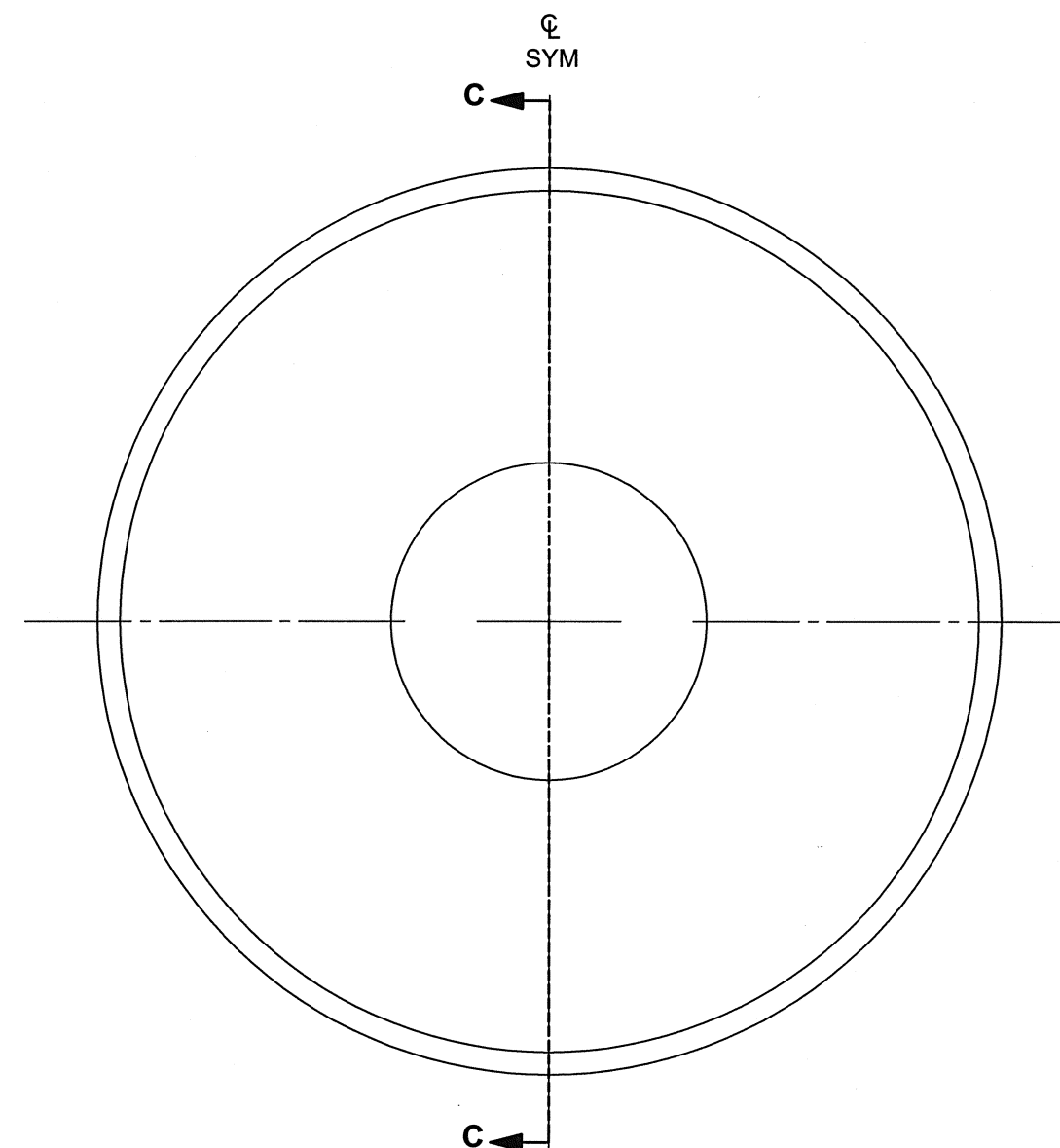
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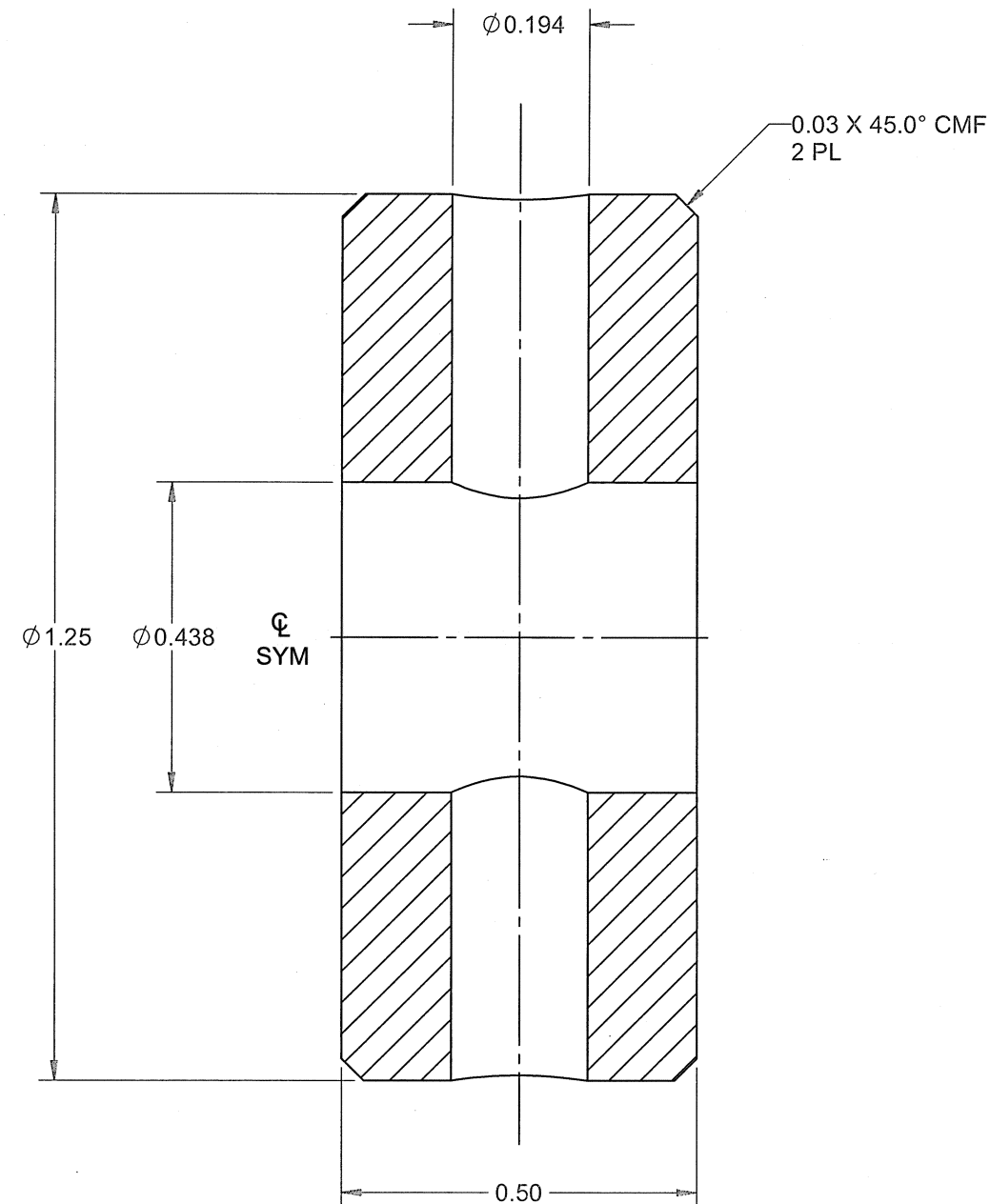
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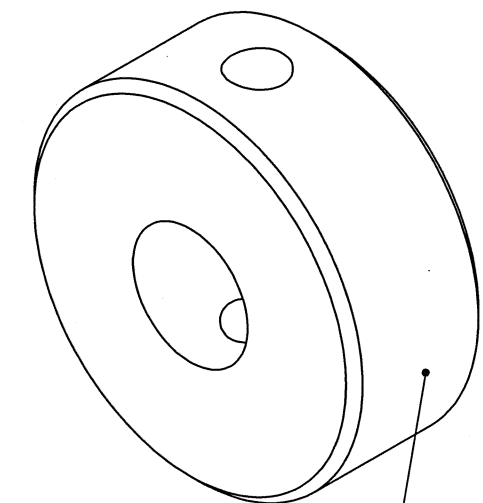


RB6795966-6 KNOB

8



SECTION C-C

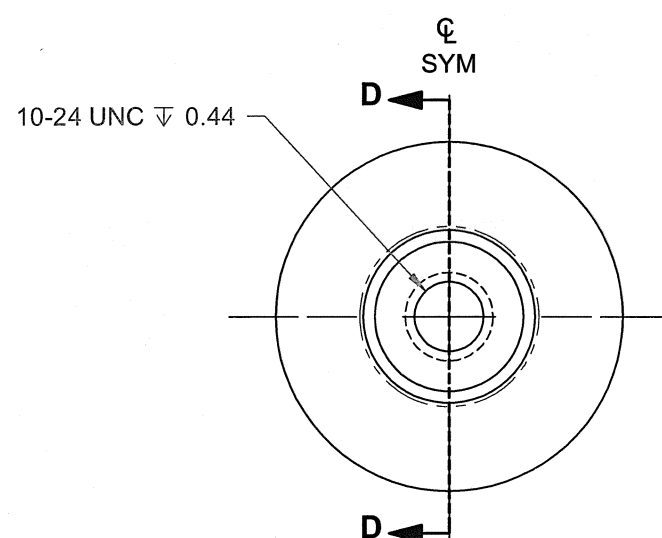
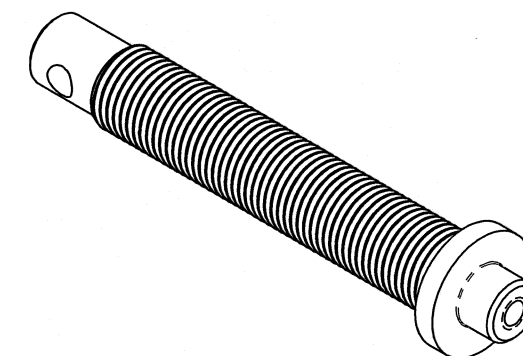


MEDIUM
DIAMOND
KNURL

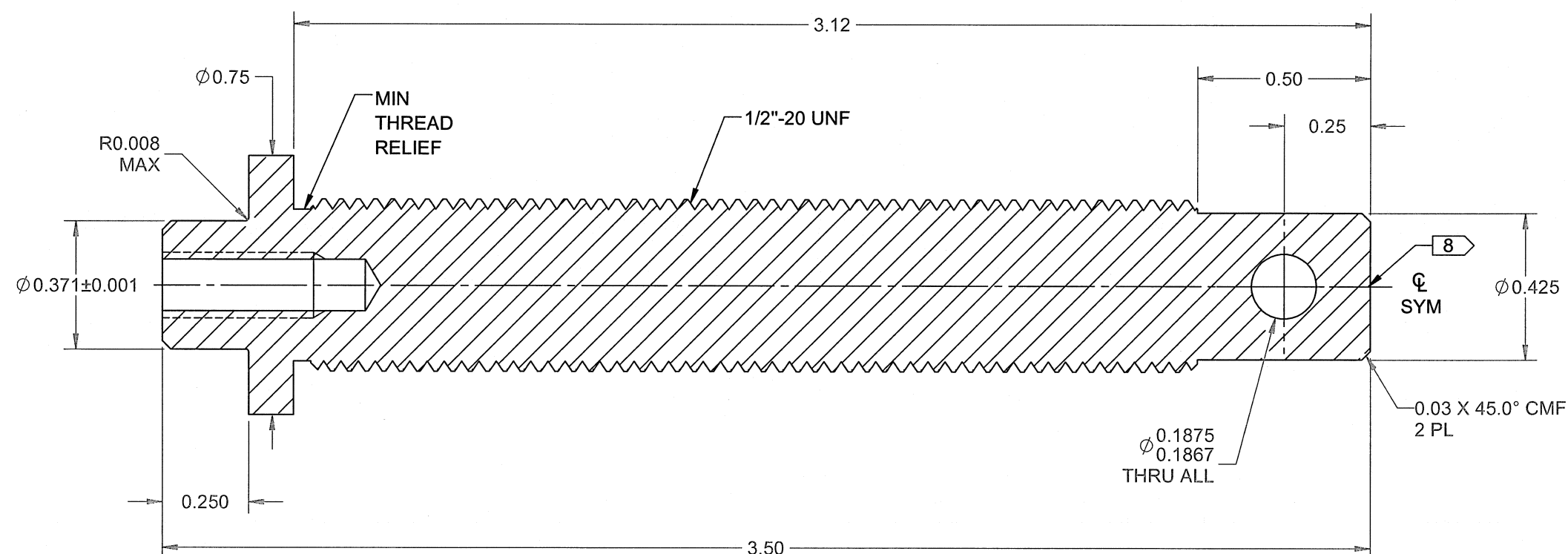
NOTES:

- 1) MATERIAL: A36/1018/1020/1025 HR
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 8 OF 13
APPROVED	VP	TITLE	SCALE
DATE	2019-08-20	COMPRESSOR FIXTURE ASSY	NTS
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RB6795966-7 JACK SCREW



SECTION D-D

NOTES:

- NOTES:
- 1) MATERIAL: 1144 STRESSPROOF
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 9 OF 13
APPROVED		TITLE	SCALE
		COMPRESSOR FIXTURE ASSY	NTS 
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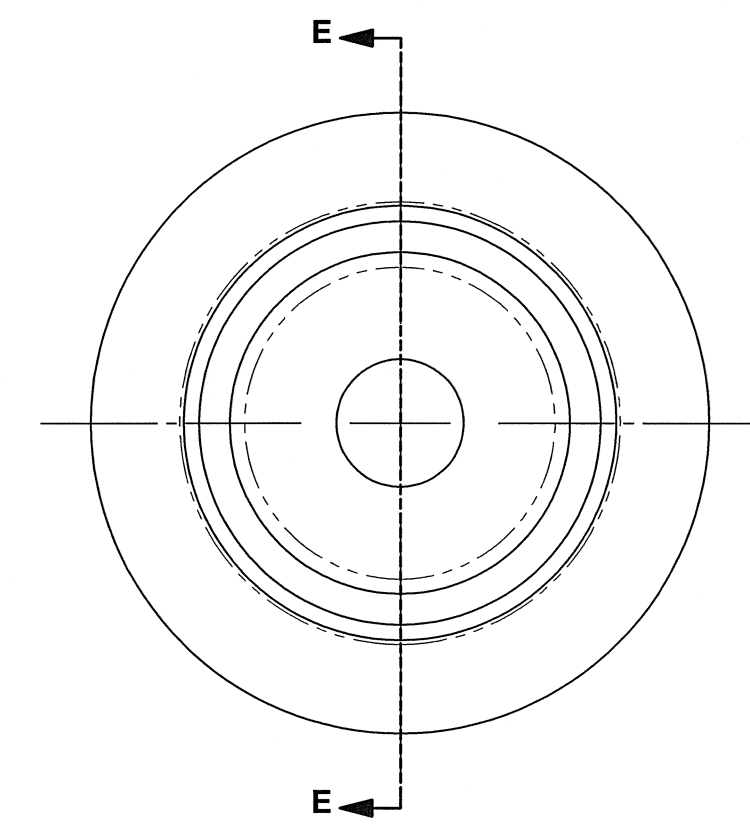
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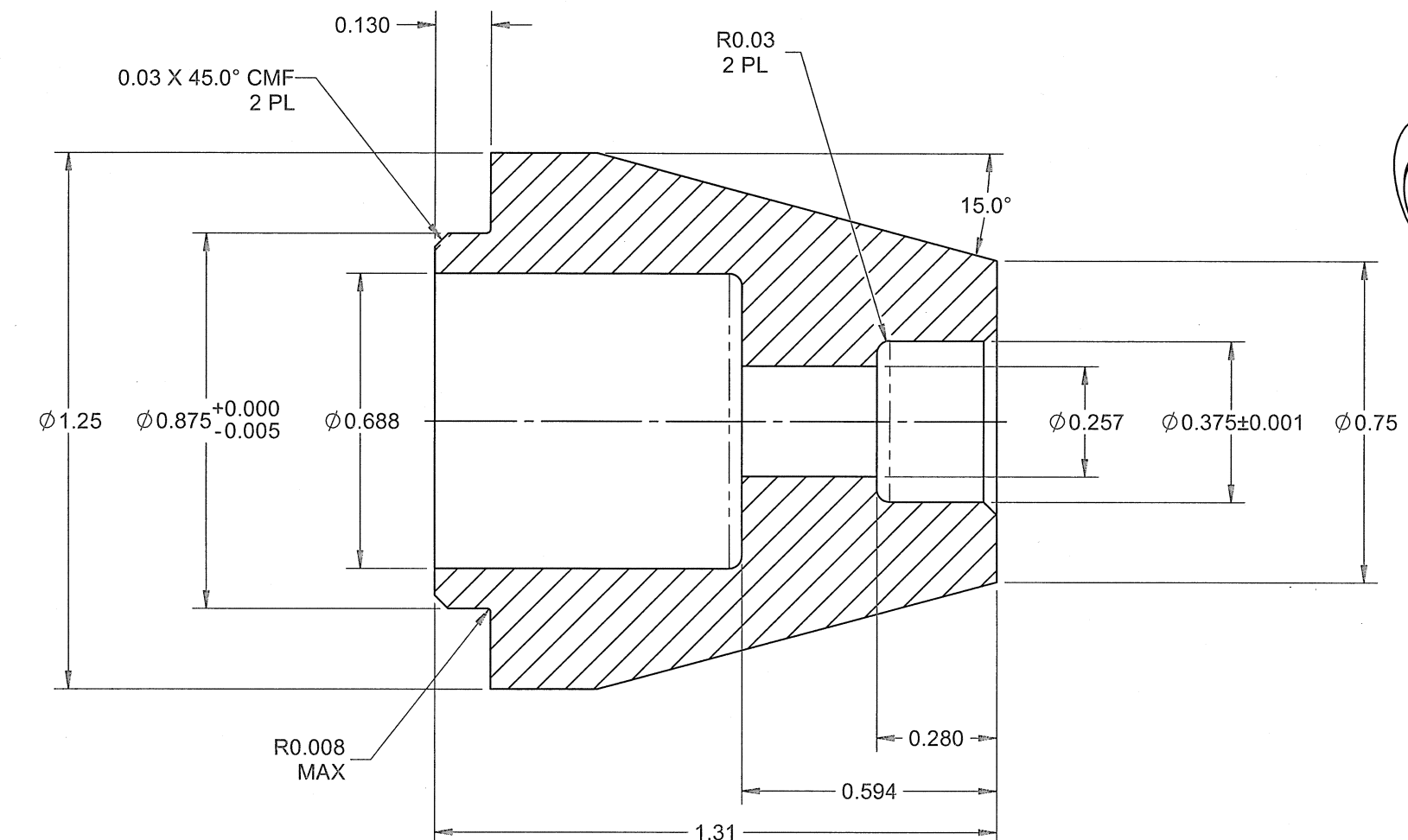
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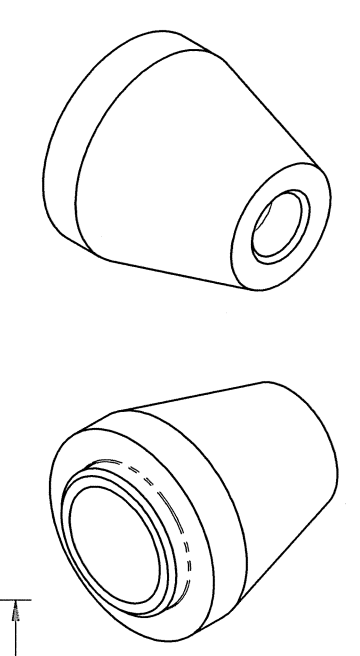
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RB6795966-8 SHOE



SECTION E-E



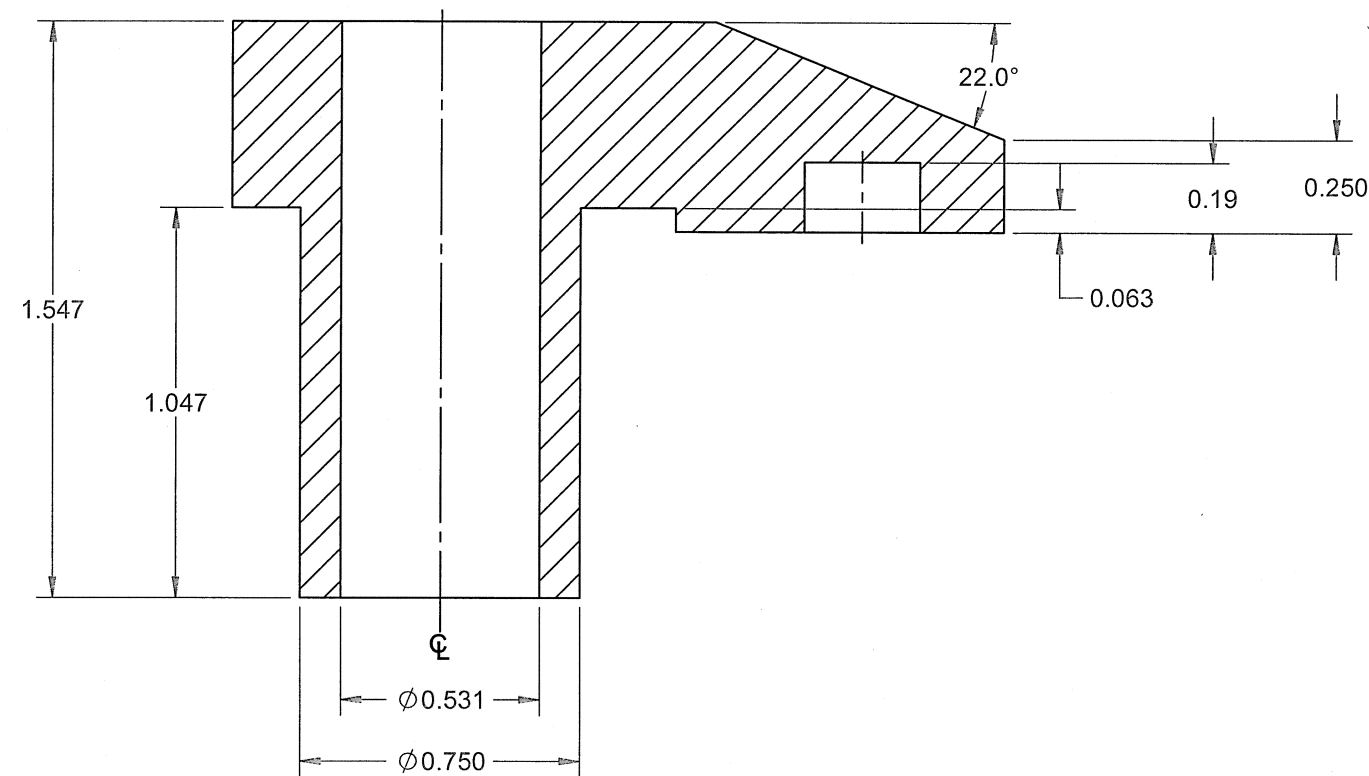
- NOTES:
- 1) MATERIAL: BRASS 360
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 10 OF 13
APPROVED	WHP	TITLE	SCALE
		COMPRESSOR FIXTURE ASSY	NTS
DATE	2019-08-20	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

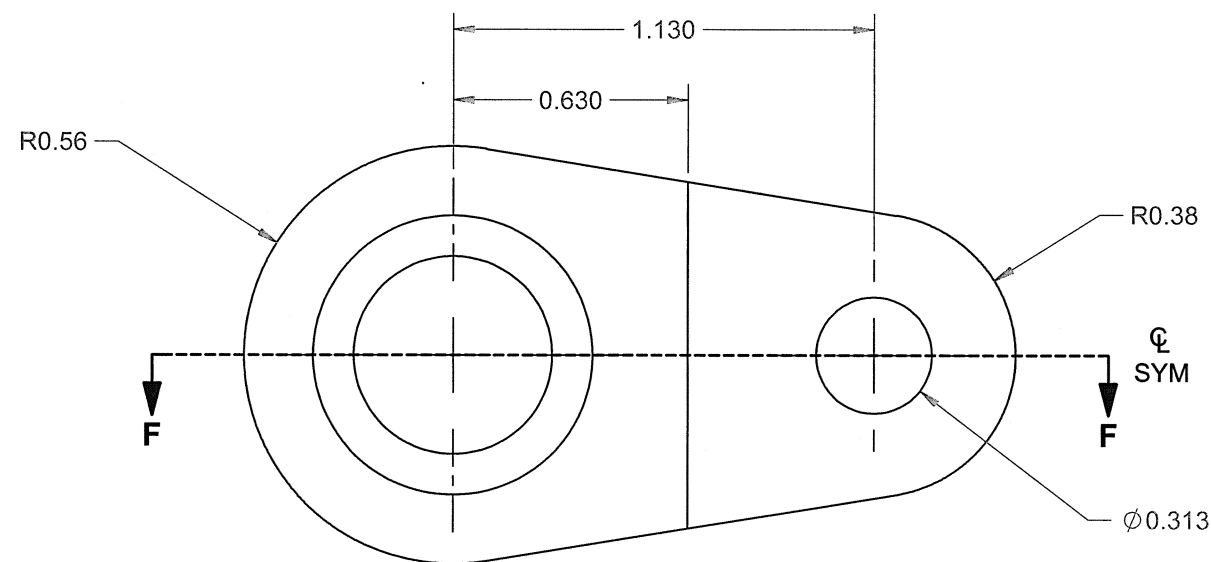
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SECTION F-F



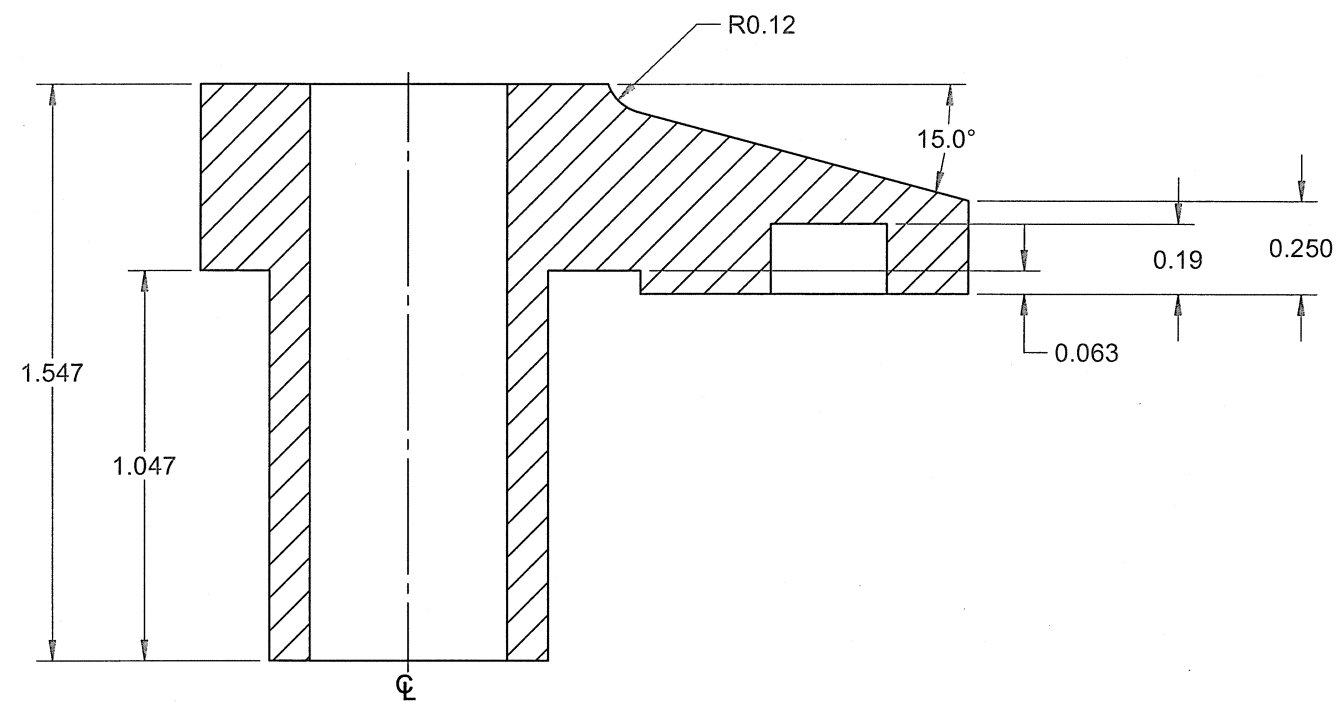
RB6795966-9 TOE CLAMP #1

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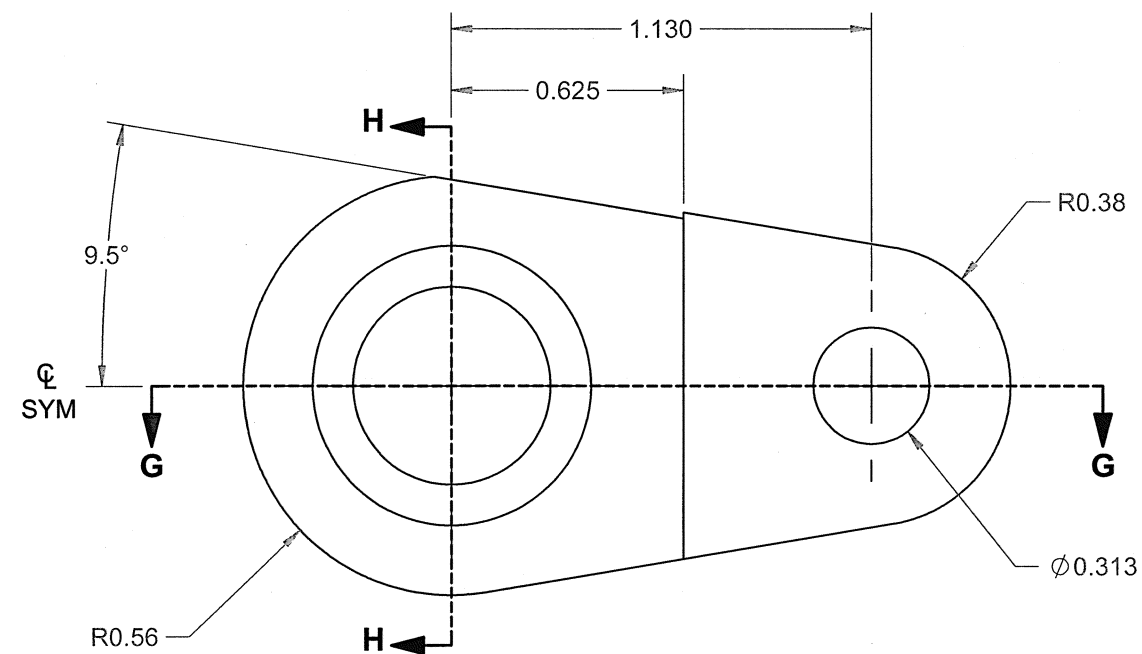
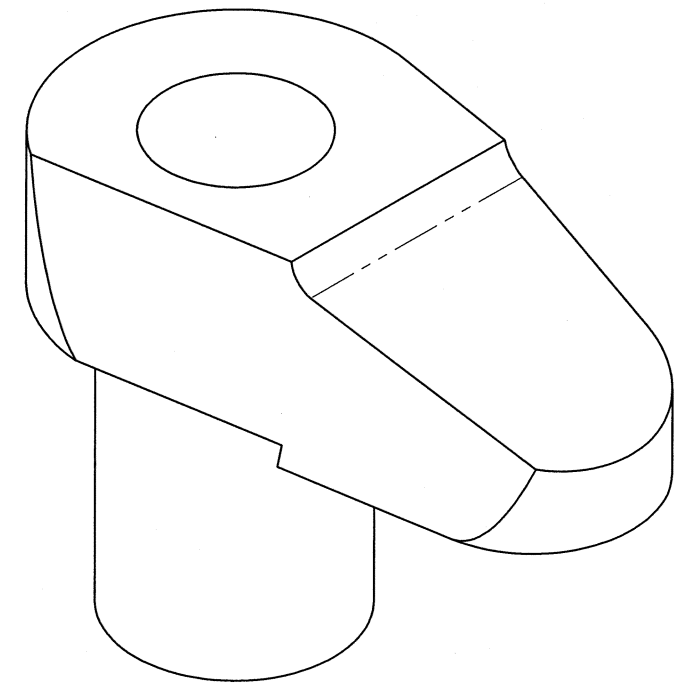
NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

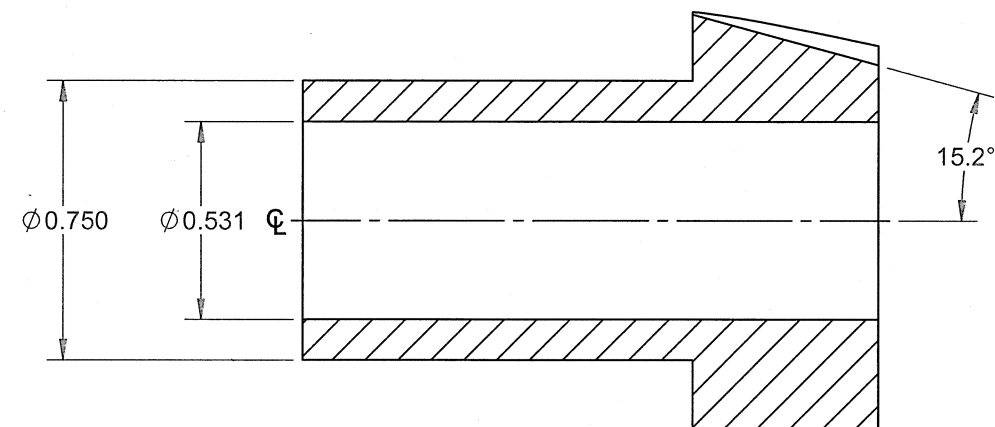
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 11 OF 13
APPROVED		TITLE	SCALE
DATE		COMPRESSOR FIXTURE ASSY	NTS
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SECTION G-G



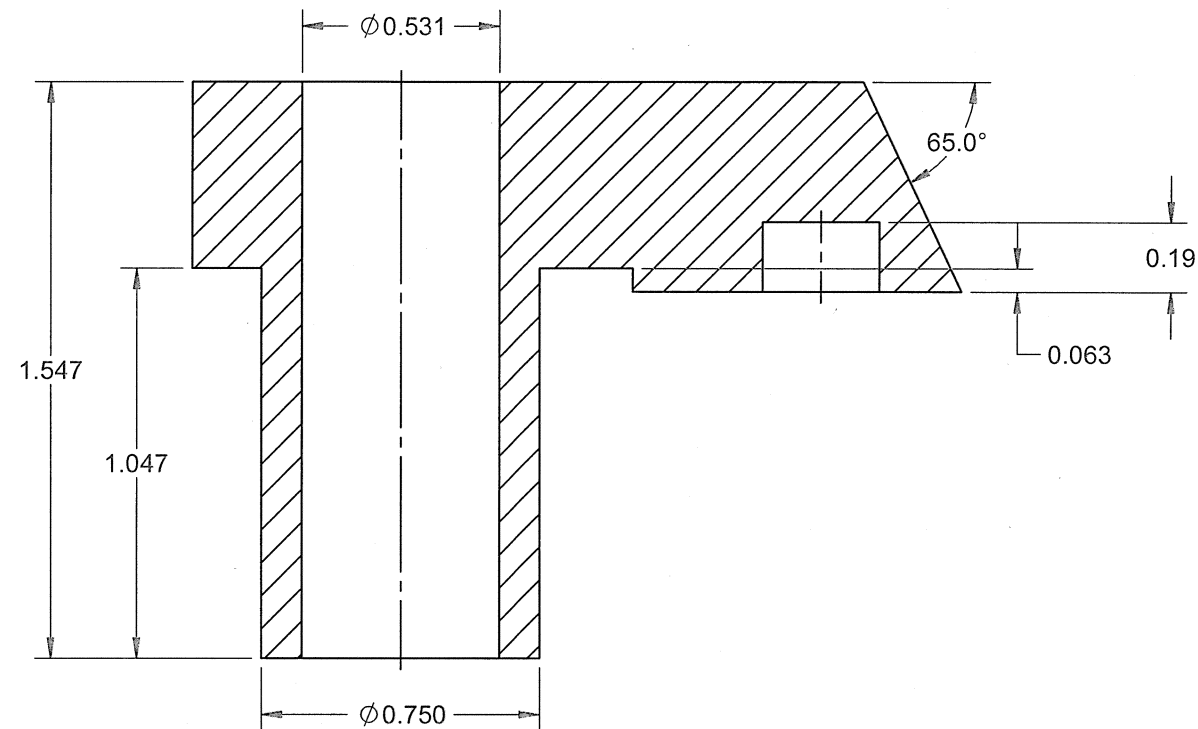
RB6795966-10 TOE CLAMP #2



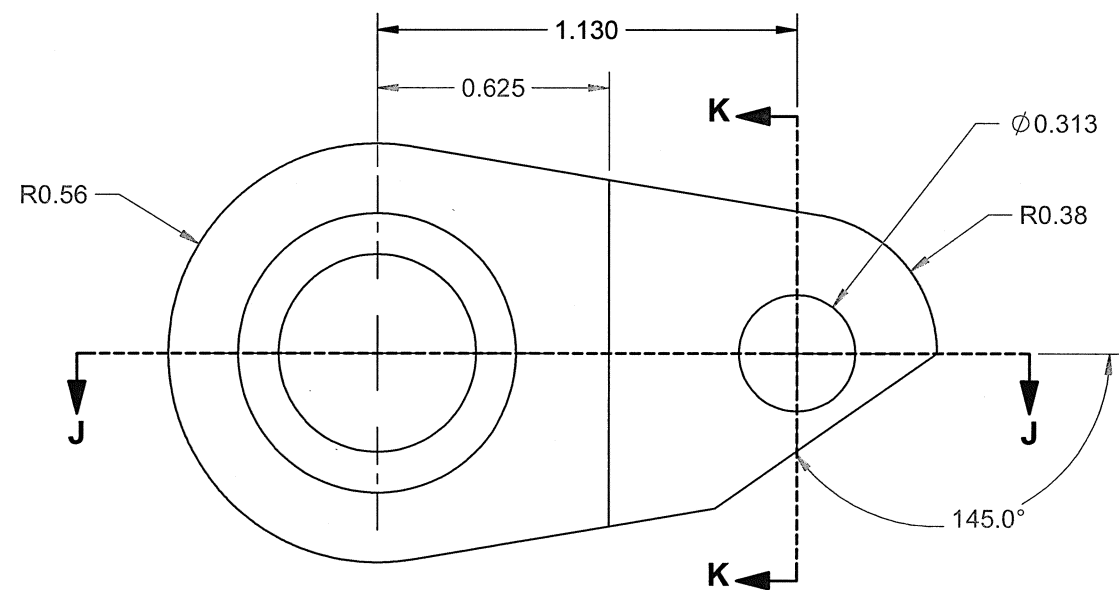
SECTION H-H

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 12 OF 13
APPROVED	WJP	TITLE	SCALE
		COMPRESSOR FIXTURE ASSY	NTS
DATE	2019-08-20	<small>COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



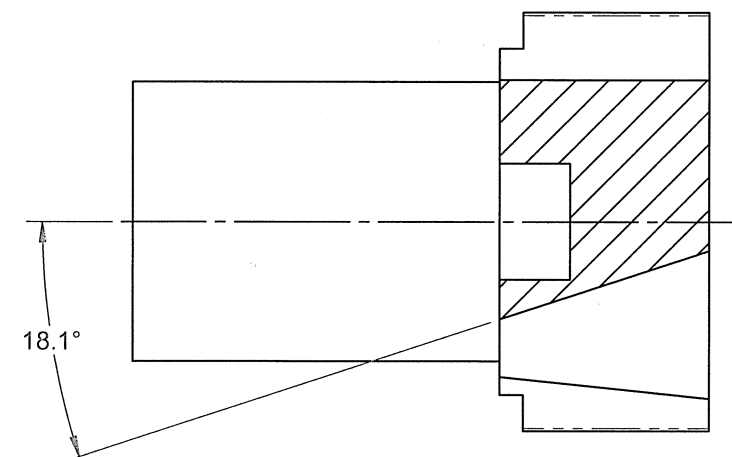
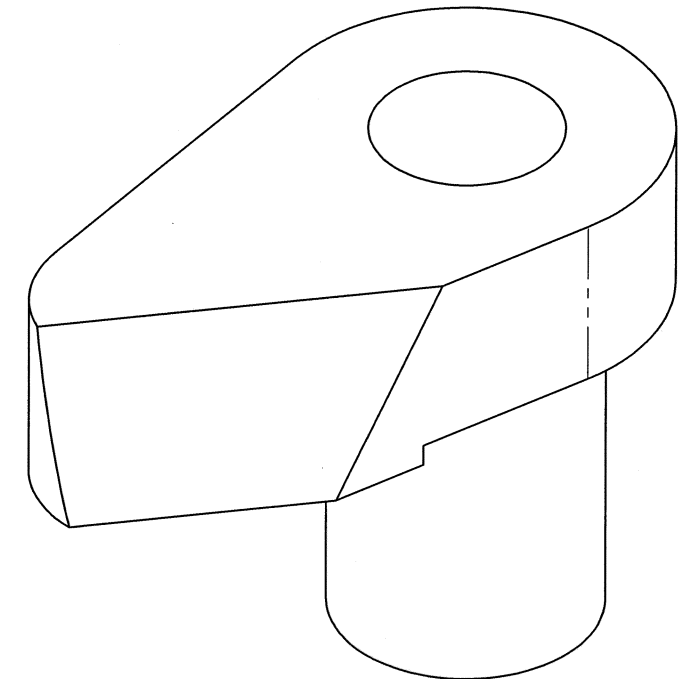
SECTION J-J



RB6795966-11 TOE CLAMP #3

8

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
 X.XX = ± 0.01 " / $\pm 0.5^\circ$
 X.XXX = ± 0.005 " / $\pm 0.1^\circ$
 X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) DIMENSIONS MUST BE MET AFTER PLATING



SECTION K-K

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6795966	SHEET 13 OF 13
APPROVED	<i>WJ</i>	TITLE	SCALE
DATE	2019-08-20	COMPRESSOR FIXTURE ASSY	NTS
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